

5110300



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D6101-015
Job Sheet 182330



Part No: D6101-015

Job Qty: 10 ea

Part Name: Saddle Billet



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/23/18

Job Tracking No:

Due Date: 9/17/18

Created By: Chantal Lavoie

Type: Stock

Description:

Note: DWG REV B IPP RevA: New issue DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	10 pcs		9/17/18	0.00	0.00	Purchasing		At 18/09/17
110	Packaging	10 pcs		9/17/18	0.00	0.00	Packaging2		At 18/09/17
120	QC	10 pcs		9/17/18	0.00	0.00	QC18		At 18/09/17
130	Packaging	10 pcs		9/17/18	0.00	0.00	Packaging3-2		SD 18/09/20
140	QC21-SA	10 Ea		9/17/18	0.00	0.00	QC21		21 SEP 26 2018

Part Op 100 - Issue P/O: 040834 b) 9.450" x 6.250" x 2.50" thick (+0.030 / -0.000) d) Grain direction along 9.450"

Descriptions: length

110 - Ensure material certification is attached

120 - Ensure Material certification comply to Dwg D6101

130 - LOCATION: MAT045

AUG 23 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-015P	Aluminum Billet	10 pcs (1 ea)	100-Purchasing	5110299

Job Allocations

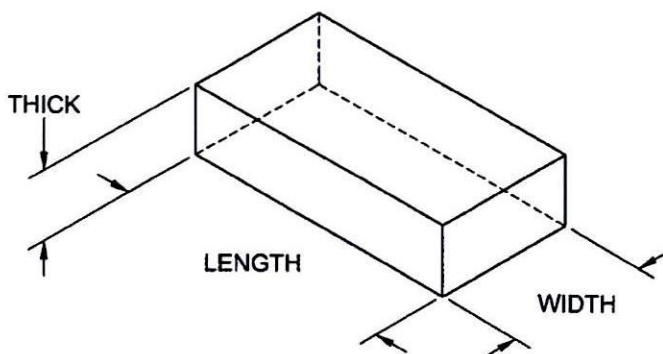
Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	D6101-015P	10	0	0

Part Specifications

Specifications could not be found.

Plex 8/23/18 6:59 AM dart.lavoie.chantal

SPECIFICATION CONTROL DRAWING



PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

△ **B** ACCEPTABLE SPECIFICATIONS FOR 7075-T7351 ALUMINUM ARE AMS-QQ-A-250/12, QQ-A-250/12, OR ASTM B209

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.10 Length
D6101-015	<u>7075-T7351</u> (QQ-A-250/12)	9.450	6.250	2.500	Along 9.450 Length
D6101-017	7075-T7351 (QQ-A-250/12)	6.350	6.250	2.250	Along 6.350 Length

△ **B**

RELEASED
09/07/15/W

B	ADDED D6101-015/-017, ADD ASTM B209	RF	09.04.23
A	NEW ISSUE	CP	01.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D6101	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SADDLE BILLET, 7075	NTS
DATE	09.04.23	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO040834

Supplier: MEC002-VU
Metaux Castle
P.O. Box 4090 Stn A
Toronto
ON
M5W OE9 Canada

PO No: PO040834

PO Date: 8/23/18

Due Date: 9/17/18

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Baker, DianePhone:
dbaker@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

E-MAILED
AUG 24 2018
Revised

Items												
Line Item	Job	Part	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	182328	D6101-001P		7075-T7351 2X6X6.25 AS PER DWG D6101 REV. B SIZE: 6.00" X 6.250" X 2.00" THICK GRAIN DIRECTION ALONG 6.00" LENGHT MATERIAL: 7075- T7351 QQ-A-250/12 TOLERANCE AS PER QUOTE +.030"/-.000"	Firmed	-	9/13/18	20 pcs	0 pcs	20 pcs	\$26.88/pcs	\$537.60
2	182329	D6101-013P		Saddle Billet : Various STC's AS PER DWG D6101 REV. B MATERIAL: 7075- T7351 (QQ-A-250/12) SIZE:10.100" X 8.250" X 2.50" THICK GRAIN DIRECTION ALONG: 10.100" LENGTH TOLERANCE AS PER QUOTE +.030"/-.000"	Firmed	-	9/13/18	10 pcs	0 pcs	10 pcs	\$73.15/pcs	\$731.50
3 <i>AT</i>	182330	D6101-015P		Aluminum Billet : Various STC's As per Dwg D6101 Rev. B	Firmed	-	9/13/18	10 pcs <i>✓</i>	0 pcs <i>10x</i>	10 pcs <i>AT 18/09/14</i>	\$52.00/pcs	\$520.00
4 <i>AT</i>	182320	D6104-005P		17-4 SS Roundbar 4.00"Od AS PER DWG D6104 REV. B MATERIAL: 17-4 PH AS PER AMS 4643 OR AISI 630	Firmed	-	9/6/17	10 pcs <i>✓</i>	0 pcs <i>10x</i>	10 pcs <i>18/09/06 AT</i>	\$54.20/pcs	\$542.00



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PURCHASE ORDER

PO040834

Items												
Line Item	Job	Part	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
				SIZE: 4.00" X 5.10" LONG								
5	182461	D6101-015P		Aluminum Billet : Various STC's As per Dwg D6101 Rev. B	Firmed	-	9/13/18	10 pcs	0 pcs	10 pcs	\$52.00/pcs	\$520.00
Grand Total:												\$2,851.10

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)
A026 certification of material conformance
A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 8/24/18 3:22 PM dart.baker.diane

CF
2013

**INTERORG TRANSFER
PACKING SLIP/
CERTIFICATE OF CONFORMANCE**

Page 1 of 2

Shipment No:3694557

Ship From: A. M. CASTLE & CO. 14001 ORANGE AVENUE PARAMOUNT, CA 90723 USA		Sold To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA		Ship To: A. M. CASTLE & CO. 2150 ARGENTIA ROAD MISSISSAUGA, ON L5N 2K7 CAN		Deliver To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA	
Date Shipped	F.O.B.	Freight Terms		Carrier		BOL No	
06-SEP-18	ORIGIN	Prepaid		YRC		3694557-2	

Shipment Details	Final Destination Branch - TOR
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Order No	Line No	Item No	Description				
5239592	1	752241.MO	2.5000.PL.7075.T7351.ALUMINUM.USI.48.5000.144.5000 CUT RECTANGLE TO 6.25 IN (+ .0310/- .0000 IN (GRAIN TO RUN ALONG 9.45")) X 9.45 IN (+ .0310/- .0000 IN (GRAIN TO RUN ALONG 9.45")) - ALUMINUM PLATE SAW SPECIFICATIONS: AMS-QQ-A-250/12				
Purchase Order No		Part Number	Ordered Qty		Invoice Qty		
40834		YOUR ITEM NUMBER: D6101-015	10.00 PCS		10.00 PCS		
Details		ALL PAPERWORK MUST FOLLOW ORDER / CUSTOMER MUST RECEIVE AT TIME OF DELIVERY ALL MATERIAL MUST HAVE IDENTIFYING MARKINGS EX:HEAT #'S Email P/s and certs to: clavoie@dartaero.com END USER: DART AEROSPACE END USE: COMMERCIAL AIRCRAFT PARTS					
Delivery No.	Mill/Source	Heat Number	Mech Id	PCS	Width (IN)	Length (IN)	Shipped Qty(LBS)
122140524	CONSTELLUM ROLLED PRODUCTS			10			152.7121

These items are controlled by the U.S. Government and authorized for export only to the country of ultimate destination for use by the ultimate consignee or end-user(s) herein identified. They may not be resold, transferred, or otherwise disposed of, to any other country or to any person other than the authorized ultimate consignee or end-user(s), either in their original form or after being incorporated into other items, without first obtaining approval from the U.S. Government or as otherwise authorized by U.S. law and regulations.

Date Printed: 06-SEP-2018 05:13:03 PM

INTERORG TRANSFER
PACKING SLIP/
CERTIFICATE OF CONFORMANCE

Page 2 of 2

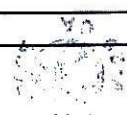
We hereby certify the material covered by this certification conforms in accordance with the above specifications and has been found to meet the applicable requirements for the material, including any specifications forming a part of the description. Test reports are on file subject to examination. All claims for defective material are waived unless made in writing to A.M. Castle & Co. within 60 days of the shipment. Material cut to the correct size, or material cut by the customer cannot be returned for credit.

Reviewed by Authorized Castle Metals Representative:

Date:

Name:

g





CERTIFIED TEST REPORT
Constellium Rolled Products
Ravenswood, LLC

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A M CASTLE & CO.
14001 ORANGE AVE.
PARAMOUNT CA
90723
US

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A M CASTLE
1420 KENSINGTON ROAD, SUITE 220
OAK BROOK IL
60523
US

A M CASTLE 110679005 4776 INCLUSION Serial:20180720-0110679005 Pg 1of2

CUSTOMER PURCHASE ORDER NO. & ITEM 465187				Constellium ORDER NO. 243922		CERTIFICATION "Constellium Rolled Products, hereby certifies that metal shipped under this order has been inspected and found in conformance with the requirements of the applicable specifications as indicated herein. Any warranty is limited to that shown on Constellium Rolled Products' standard General Terms and Conditions of Sales. Test reports are on file, subject to examination." Constellium Rolled Products Ravenswood, LLC 859 Century Road P.O. BOX 68 RAVENSWOOD, WV 26164 USA  Dave Dunbarger - Laboratory Manager
ALLOY 7075	CLAD	TEMPER T7351	GAUGE 2.50000 in 63.50 mm	WIDTH 48.50000 in 1,232 mm	LENGTH 144.50000 in 3,670 mm	
ITEM ORDERED SPEC PLATE, SAWED MILL FINISH						
CUSTOMER SPECIFICATION AMS 4078J						
PART NUMBER 752241		B/L NUMBER 103264		DATE SHIPPED 07/20/2018		
WT. SHIPPED 7120.000 LB		NO. OF PIECES 000004		GOVT. CONTRACT NO.		

ALL LOTS ON THIS CERTIFICATION ALSO CONFORM TO THE FOLLOWING REQUIREMENTS:

ASTM B594 REV 13 2013 100% SONIC W/ 0.12" DEADZONE Class A
AMS QQ-A-250/12A
AMS-STD-2154G 2017 TYPE1 CLASS A 100% SONIC MINUS DEADZONE
ASTM B209-14
BSS-7055B 2013 CLASS A 100% SONIC TESTED MINUS DEADZONE
CMMP025 REV V
CSTI006 REV E 2011 CLASS A 100% SONIC MINUS DEADZONE
DPS 4.713 REV AK 2012 CLASS A 100% SONIC MINUS DEADZONE
GAMPS 9101 REV B 2006 CLASS A 100% SONIC MINUS DEADZONE
MMS 159T
PS 21211P 2010 CLASS A 100% SONIC MINUS DEADZONE

Load Details

Package	Net Lbs	Kg	Lot	Piece	Serial	Parent Lot
1001828110	1,780.000	807.394	9420913	01		
1001828110	1,780.000	807.394	9420913	02		
1001828111	1,780.000	807.394	9420913	03		
1001828111	1,780.000	807.394	9420913	04		

Lot: 9420913 (See test results below)

Tensile - Room Temperature (US)

		Ultimate (KSI)		Yield (KSI)		Elongation (%)		Report
Direction	Tests	Min	Max	Min	Max	Min	Max	
LT	02	72.6	74.4	61.0	63.8	11.5	11.5	





CERTIFIED TEST REPORT
Constellium Rolled Products
Ravenswood, LLC

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A M CASTLE & CO.
14001 ORANGE AVE.
PARAMOUNT CA
90723
US

**S
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D
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O**

A M CASTLE
1420 KENSINGTON ROAD, SUITE 220
OAK BROOK IL
60523
US

A M CASTLE 110679005 4776 INCLUSION Serial:20180720-0110679005 Pg 2of2

CUSTOMER PURCHASE ORDER NO. & ITEM 465187				Constellium ORDER NO. 243922		CERTIFICATION "Constellium Rolled Products, hereby certifies that metal shipped under this order has been inspected and found in conformance with the requirements of the applicable specifications as indicated herein. Any warranty is limited to that shown on Constellium Rolled Products' standard General Terms and Conditions of Sales. Test reports are on file, subject to examination." Constellium Rolled Products Ravenswood, LLC 859 Century Road P.O. BOX 68 RAVENSWOOD, WV 26164 USA  Dave Dunbarger - Laboratory Manager	
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PART NUMBER 752241		B/L NUMBER 103264		DATE SHIPPED 07/20/2018			
WT. SHIPPED 7120.000 LB		NO. OF PIECES 000004		GOVT. CONTRACT NO.			

Tensile - Room Temperature (SI)							
		Ultimate (N/MM2)		Yield (N/MM2)		Elongation (%)	
Direction	Tests	Min	Max	Min	Max	Min	Max
LT	02	501	513	421	440	11.5	11.5

Conductivity % IACS MIN 39.3 MAX 39.4 % MS/M MIN 22.8 MAX 22.9

Chemistry (Actual)

	SI	FE	CU	MN	MG	CR	ZN	TI	ZR
Core	0.08	0.18	1.41	0.06	2.66	0.21	5.65	0.03	0.00

OTHERS-EACH: .05 MAX. OTHERS TOTAL: .15 MAX. AL REMAINDER

All material contained in this lot was cast and manufactured in the USA

QUALITY TEXTS:
AMC CA-15413B R 6

THIS TEST REPORT SHALL NOT BE REPRODUCED EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF THE LABORATORY OR AUTHORIZED QUALITY DELEGATE. THE RECORDING OF FALSE, FICTITIOUS, OR FRAUDULENT STATEMENTS OR ENTRIES ON THE CERTIFICATE MAY BE PUNISHED AS A FELONY UNDER FEDERAL LAW.

CHEMISTRY BY OES: ARKSPARK

CHEMISTRIES REPORTED IN PERCENTAGE BY WEIGHT

WHEN FRACTURE TOUGHNESS TEST REQUIRED, TESTED PER ASTM E399

WHEN TENSILE TEST REQUIRED, TESTED PER ASTM E8; B557

DUNS Number: 090570149; CAGE Code: 1YWL9

Mercury is not a normal contaminant in aluminum alloys and neither mercury nor any of its compounds were utilized in the manufacture of our product.

"END OF CERTIFICATION"

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: D6101-015
 DATE: 18/09/14

PO / BATCH NO.: P0040834/S110300

MATERIAL CERT REC'D: Yes
 QUANTITY RECEIVED: 10x
 QUANTITY INSPECTED: 10x
 QUANTITY REJECTED: 0

THICKNESS ORDERED: 2.500"
 THICKNESS RECEIVED: 2.500"
 SHEET SIZE ORDERED: —
 SHEET SIZE RECEIVED: —

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y ☒ N	
CORRECT FINISH	☒ Y N	
CORROSION	Y ☒ N	
CORRECT GRAIN DIRECTION	☒ Y N	
CORRECT MATERIAL PER M-DRAWING	☒ Y N	AMS QQ-A-250/12
CORRECT THICKNESS	☒ Y N	
PHOTO REQUIRED	Y ☒ N	
CORRECT REF # TO LINK CERT	☒ Y N	HT: 9420913
CORRECT MATERIAL IDENTIFICATION	☒ Y N	
CORRECT M# ON THE MATERIAL	☒ Y N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y ☒ N	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y ☒ N	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
TYPE OF MATERIAL	HRC	HRB	DUR A	DUR D	WEBSTER
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION	ENGINEERING SIGNOFF (if required)
INSPECTED BY: <u>AT</u> DATE: <u>18/09/14</u>	SIGNED OFF BY: _____ DATE: _____

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in